

Work Order ID 56318

February 17, 2010 2:37:01 PM



Page 1

Item ID: D3783-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lateral Brace Assembly

Start Date: 2/17/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3783

Rev A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-assemble as per dwg D3783

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

EB 10/02/22 (4)

EB 10/02/22 (4)

S. 10/02/23

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56318

February 17, 2010 2:37:01 PM



Item ID:	D3783-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lateral Brace Assembly					
Start Date:	2/17/10	Start Qty:	6.00		Cust Item ID:	
Required Date:	2/24/10	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124 	Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3 M112588	0.00							
Powdercoat	Memo	0.00							
Powder Coating	***Mask inside D3765-1 clevis***								
	POWDER COAT: Start Time: 7:15am Oven Temperature: 320°F Finish Time: 7:45am								
127 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
130 	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									

⇒ JH 10/02/24 (X4) Ø

BK 10-02-24 (4)

Pc 10/3/01 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3783-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lateral Brace Assembly

Start Date: 2/17/10 Start Qty: 6.00

Required Date: 2/24/10 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

CL 03/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56318

Parent Item: D3783-041

Parent Item Name: Lateral Brace Assembly


Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
 IPP Rev:B 08-06-17 rev.a as per dwg DD verified by:EC IPP RevC: add
 powder coat for ease of manufacturing DD 10.01.13 verified by:EC

Start Date: 2/17/10

Required Date: 2/24/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN5-13A		Purchased	No			110	Each	64.0000	12.0000			
												
Bolt												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

64

104936

3

108167

8

110363

14

112492

10

113237

29

QSI017 NAS1149D05633

M113524

16x

AN960JD516

Purchased

No

110

Each

0.0000

16

~~24.0000~~

Washer

D3765-1

Manufactured

No

110

Each

12.0000

8

~~42.0000~~

Clevis

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

42766

4

54343

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 17, 2010 2:37:06 PM

Work Order ID: 56318



Parent Item: D3783-041



Parent Item Name: Lateral Brace Assembly

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
 IPP Rev:B 08-06-17 rev.a as per dwg DD verified by:EC IPP RevC: add
 powder coat for ease of manufacturing DD 10.01.13 verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3769-1		Manufactured	No			110	Each	4.0000	4.0000			
Tube												

ES 10/02/22

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

54344

4

MS21042L5

Purchased

No

110

Each

447.0000

12.0000



Nut

ES 10/02/22

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

446

110382

10

111636

1

112314

16

113523

219

113537

200

Main Warehouse

ST139

1

112314

1

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

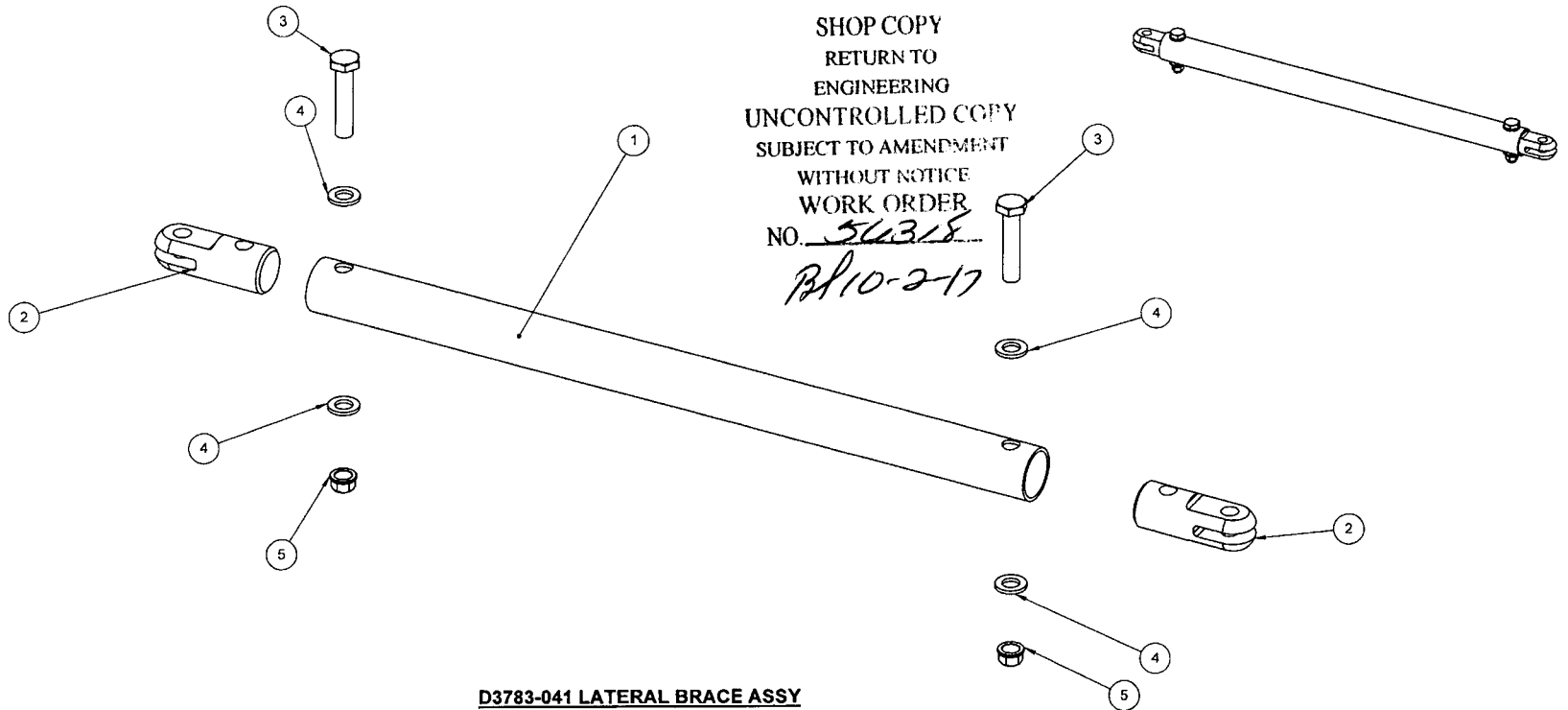
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 56318
PL10-2-17



D3783-041 LATERAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3769-1	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

RELEASED
 08-06-11/11

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.52 lbs

REV.	NEW ISSUE	HS	08.06.04
DESIGN	HS	BY	DATE
DRAWN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3783	SHEET 1 OF 3
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D3783-043 LONGITUDINAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	AN5-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	2
5	MS21042L5	NUT	1

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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
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NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.41 lbs

w/o 56318

RELEASED
08-06-16

D3783-045 ANGLE BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3769-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.63 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3783	SHEET 3 OF 3
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w/0 54318

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